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Work Orden				*759	68*							Page	1
Item ID: Revision ID: Item Name:	D3255-1 Panel			Accept	*N900	040	100) * :	Setup S	Start Stop		S1* S2*	=
Start Date: Required Date: Reference:	02/11/2011 16/11/2011	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:						ı u	. 7/	
Approvals:	Process Pla	an: M.C.J	Date: 11111 C	Tooling:	D	ate:	_	l		Start	*N	R1*	
· ·			•			ate:			\$	Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		leject Iumber	Insp. Stamp	_
Draw Nbr	Rev	vision Nbr											_
D3255	Rev	/ В											
*100 *100* Waterjet FLOW CNC Waterjet	et	FLOW WATER JET Memo 1-Cut as pe Deburr if n		0.00 0.00 ev: B Prog Rev: B _	2-				- <u> </u> -8	<u>) </u>			_
*110 *110* QC Quality Control		QC2- Inspect parts off r	nachine FAI/FAIB	0.00				BI	1-(1-9)	<u> </u>			_
120	•	QC8- inspect parts - sec	ond check	0.00	~								

120

Memo

Bolulu Zoo.o

Quality Control

	-								
W/O:			V	VORK ORDER CHANGE	ES			· ,	
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
P. F. L.									
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A :	Date: _	
	Re	esolution:	Disposit	ion:	QA: N/C	closed:		Date: _	
NCR:		WC	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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Work Orde November-02-11				*759	68*				Page 2	
Revision ID: Item Name: Start Date: Required Date:	D3255-1 Panel 02/11/2011 16/11/2011	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N900 Cust Item II Customer:		n* s	Setup Star Stop	וכימו	
Reference: Approvals:		an:	Date:	Tooling: SPC (Y/N):		te:		Run Star Stop	NRI	
Sequence ID/ Work Center II 130 *130* Brake NC Brake NC)	Operation Description NC BRAKE Memo Form as per	Dwg D3255	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	_
*140 *140* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	lules		(A)			
150 *150* Packaging		Identify as per dwg & St	ock Location:	0.00			Sp	11-1	1-16.	

Packaging

	P	2 -14								
W/O:			W	ORK ORDER (CHANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Desc	ription	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief En	g	Date		<u> </u>		<u> </u>
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Work Ord November-02-1				*75968*						-	Page 3		
Item ID: Revision ID: Item Name:	D3255-1 Panel			Accept	*N900	040	100)*	_	Start Stop	*NS1* *NS2*		
Start Date: Required Date: Reference:	02/11/2011	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:							
Approvals:	Process Pla	Process Plan: Da		Tooling:	Date:		_		Run Start		*NR1*		
	QC:		Date:	SPC (Y/N):		ate:				Stop	*NR2*		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Insp. Number Stamp		
*160 *160* QC		QC21- Final Inspection -	Work Order Release	0.00						1/11	1114		
Quality Control									P	11-1	1-14		

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approvat Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			verificat			Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Secti	ion C	Chief Eng	QC Inspector
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Picklist Print

November-02-11 10:43:36 AM

Work Order ID: 75968

75968

Parent Item:

D3255-1

D3255-1

Parent Item Name:

Panel

Start Date: 02/11/2011

Required Date: 16/11/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	110.8600	1.484	9.372632	<u> </u>		
M304S22	CA								**	R	·- (1-9)		

304/316 .032 Sheet

Location	Loc Qty	Loc Code	
020	3.3		
109057	3.3		
MAT020	107.56		·
117379	30.06		117374
118271	73		
118400	4.5		

W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
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DATE	OTED	Description of NC	Description of NC Corrective Action Section B Verification				n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		1.00						
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DART AEROSPACE LTD	Work Order:	75968
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001					
15.171	+/-0.010	15,171	> ≥		V BOZ	
10.032	+/-0.010	10.032			T ARGI	
6.902	+/-0.010	6,910	2	7	₹/	
18.456	+/-0.010	18.456	2		7	
11.432	+/-0.010	11.432	2		7	
		11. 130	-			
		***			7.5	
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Measured by:	B	Audited by:	λ,	Prototype Approval:	N/A
Date:	11-11-9	Date:	44108	Date:	N/A

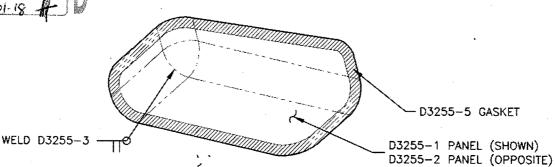
Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	<u> </u>
				

W/O:	WORK ORDER CHANGES				GES					
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Part No:		PAR #:	_ Fault Ca	tegory:	NC	R: Yes 1	No DQA	:	Date:	
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NCR:		W	ORK OR	DER NON-CONFORM	MANCE	(NCR)				
DATE	STED Description of NC		Corrective Action Section B				Verifica	ation	Approval	Approval
DATE	STEP Description Section	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
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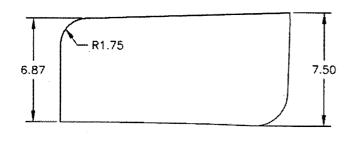


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	.41	- H	D3255	SHEET 1 OF 4
DATE			TITLE	SCALE
 04.1	2.06		ACCESS PANEL ASSEMBLY	1:6
Α		04.01.27	NEW ISSUE	
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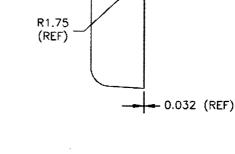
04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098

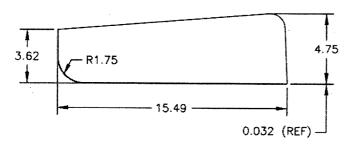


D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



В





SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER 75968HLJ

11/11/02

D3255-041/-042 NOTES:

1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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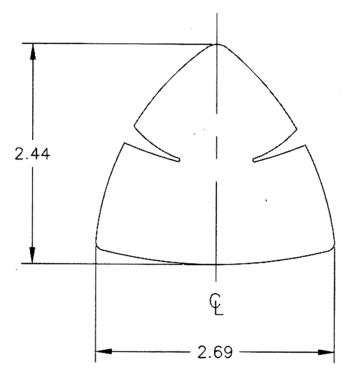
D3255-1 BEND DETAIL D3255-2 OPPOSITE

W/O:	WORK ORDER CHANGES			S						
DATE	STEP	PROC	EDURE CH	IANGE	Ву	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		We	ORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verification			Approval	Approval
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47	1	D3255	SHEET 2 OF 4
DATE	······	TITLE	SCALE
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D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

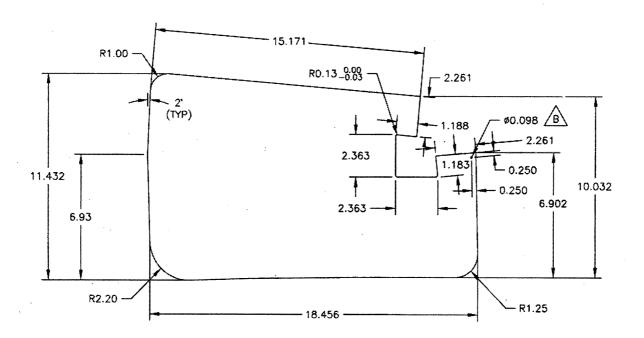
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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W/O:		WORK ORDER CHANGES									
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	P	#	D3255	SHEET 3 OF 4
-	DATE		TITLE	SCALE
	04.12.06		ACCESS PANEL ASSEMBLY	1:5



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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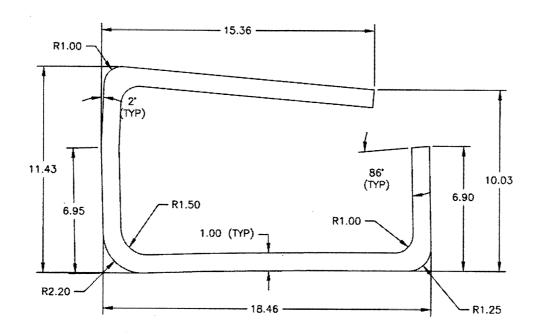
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:			NCR: Yes	No DQA :	Date: _				
Resolution: Disposition:											
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NCR)						
DATE	STED Description of NC		Corrective Action Section			Verification	Approval	Approval			
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D3255-5 GASKET

- <u>D3255-5 NOTES:</u>
 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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